

Work Order ID 133241

Wednesday, May 27, 2015 3:38:58 PM

133241

Page 1

Item ID: PB67-43001-211

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Square Tube

Start Date: 5/27/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: umf Date: 5-5-21

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	D								

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

- 1- Cut to length as per dwg
- 2- Make a chamfer on both ends of tube as per dwg
- 3- Deburr

12 FF MAY 28 2015

110

QC5- Inspect part completeness to step on W/O 0.00

110

QC

Memo

0.00

Quality Control

(12) DAS
38
9-89
MAY 29 2015

120

Identify as per dwg & Stock Location: WA003 0.00***120***

Packaging

Memo

0.00

Packaging

LOCATION: WA003

SE12 NO MAY 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
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Required Date: 6/5/2015 Req'd Qty: 12.00

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ

JUN 03 2015

mf

15-6-2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																						

Picklist Print

Wednesday, May 27, 2015 3:38:57 PM

Page 1

Work Order ID: 133241

133241

Parent Item: PB67-43001-211

PR67-43001-211

Parent Item Name: Square Tube

Start Date: 5/27/2015

Required Date: 6/5/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
14.12.16 DWG REV.D DD VERF:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS1.000W.12 0		Purchased		No			f	42.0000		14			

M6061T6TS1 000W 120

6061T6 SQ TUBE 1.00 x 1.00 X .120w

ff

Location

MAT051

128248

m126686

Loc Qty

42

42

Loc Code

20

DQA: _____ Date: _____

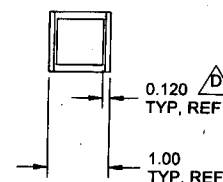
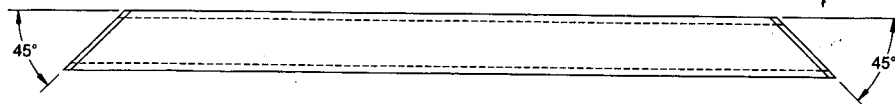


WORK ORDER NON-CONFORMANCE / UPDATE

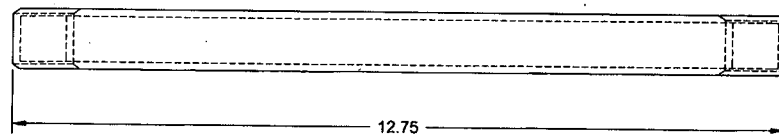
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



0.08 X 45° CHAMFER
4 PL



B67-43001-211 SQUARE TUBE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6TS1.000W0.120
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

D	0.120 WALL THICKNESS WAS 0.085, 0.08 CHF WAS 0.06 REASON: PURCHASING REQUEST, FACILITATE MFG	DB	14.07.21
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 17 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.02.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-211 TITLE SQUARE TUBE COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DB		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	N/A	REV. D SHEET 1 OF 1 SCALE NTS	
DATE	14.07.21		

RELEASED
2014-12-08

13 3241

DQA: _____ Date: _____



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